

Work Order ID 50765

July 22, 2009 6:54:54 AM

Page 1

Item ID: D3296-1
Revision ID: A
Item Name: Door Panel

Accept

Setup Start
Stop

Start Date: 7/22/09 Start Qty: 20.00
Required Date: 7/22/09 Req'd Qty: 20.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: W Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3296	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3296 Dwg Rev: A Prog Rev: A 12-
Deburr if necessary

18 9-7-22

(24)

(P10) →

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

18 9-7-22

(24)

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ 8/6/22

Counts
(K23) *15CAD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3296-1 PAR #: 2/12 Fault Category: Sm FAB NCR: Yes No DQA: / Date: 09-08-11
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 09-08-17

NCR: <u>50765</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/12	water jet # 110	Found one part Qty x1 with a cut at and the hole centre to edge 0.286" should be .300" +/-.	<u>/</u> bsimur	Scrap and Destroy Qty x1 no replace extras were made	<u>IB</u> 9/7/12	<u>/</u> 09/07/12	<u>/</u> bsimur	<u>S</u> 09/07/12
		Parts were <u>cut</u> close together. R.C. process	<u>/</u> bsimur	<u>/</u>	<u>/</u>	<u>/</u>	<u>/</u> bsimur	<u>S</u> 09/07/12

NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo
Debur

Handwritten: n/a S

0.00

0.00

Handwritten: done @ 100

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

Handwritten: BR 09-07-23

Handwritten: 23 in a circle

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

Handwritten: => 802/07/24

Handwritten: counted 23 in a circle with a checkmark

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop



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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 186

0.00



Packaging

Memo

0.00

Packaging

PC 8/1/07 (23)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

105-08 11
10

W 9.8.06

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1/1

Work Order ID: 50765

Parent Item: D3296-1RevA

Parent Item Name: Door Panel

Comments:

Start Date: 7/22/09

Required Date: 7/22/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	158.6888	13.8863			



2024-T3 .063 sheet

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT	158.6888421
102942	1.5
105916	3.69
106223	1.47
109463	24.2
110980	15.45
111787	110.378842
19059	2

110347

~~110347 102942 105916 106223 109463 110980 111787 19059~~

109463 X 12

110351 X 12

B 9-7-22

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

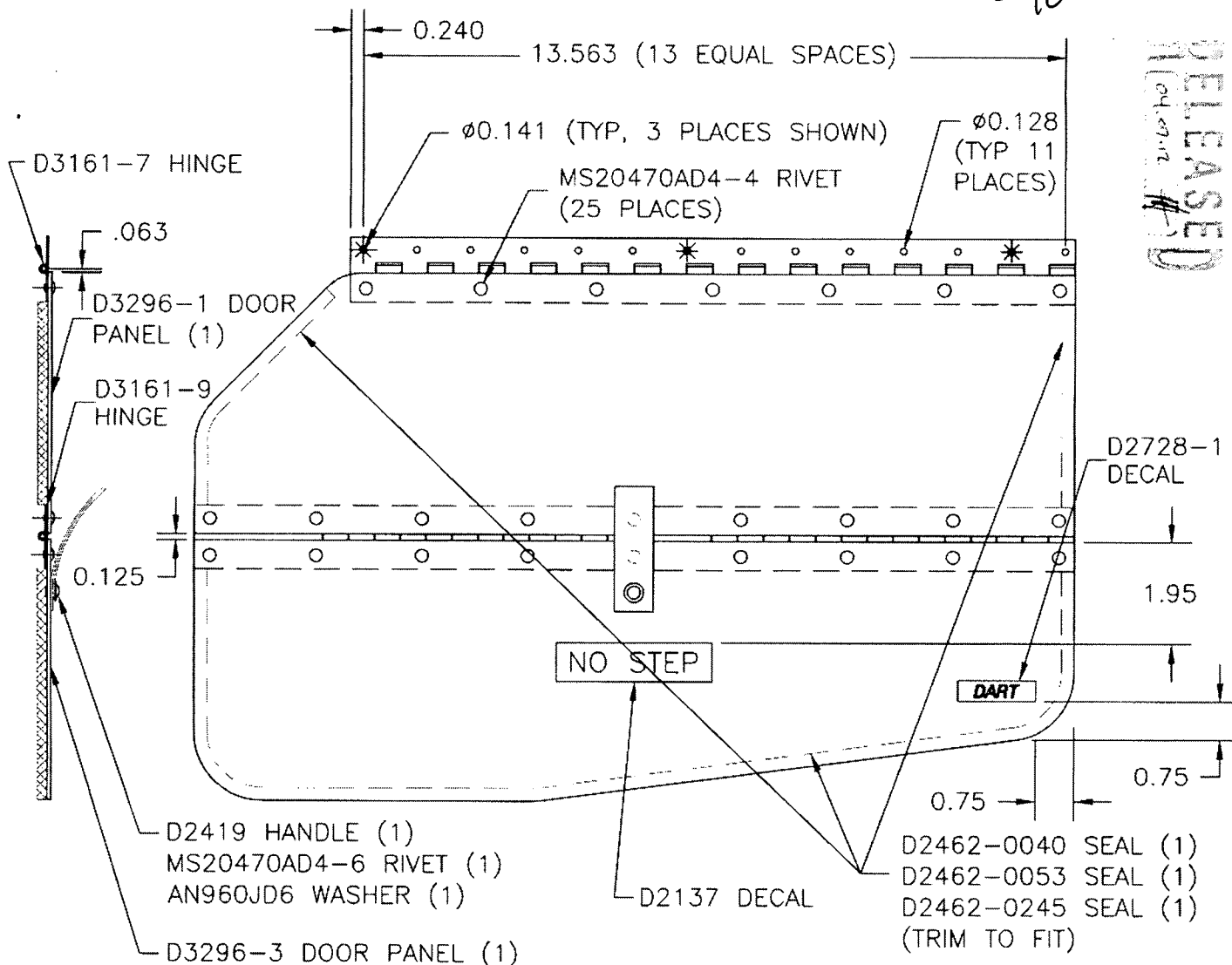
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296
DATE 04.06.28	TITLE DOOR ASSEMBLY	REV. A 1 OF 2
A	04.06.28	SCALE 1:3
	NEW ISSUE	



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

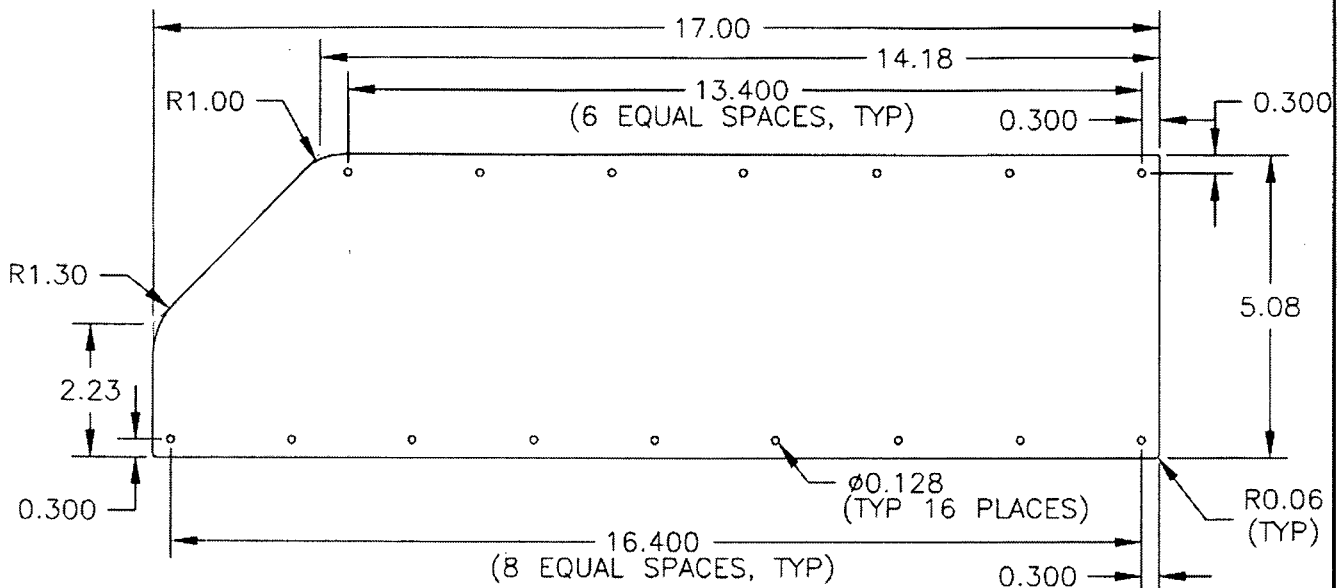
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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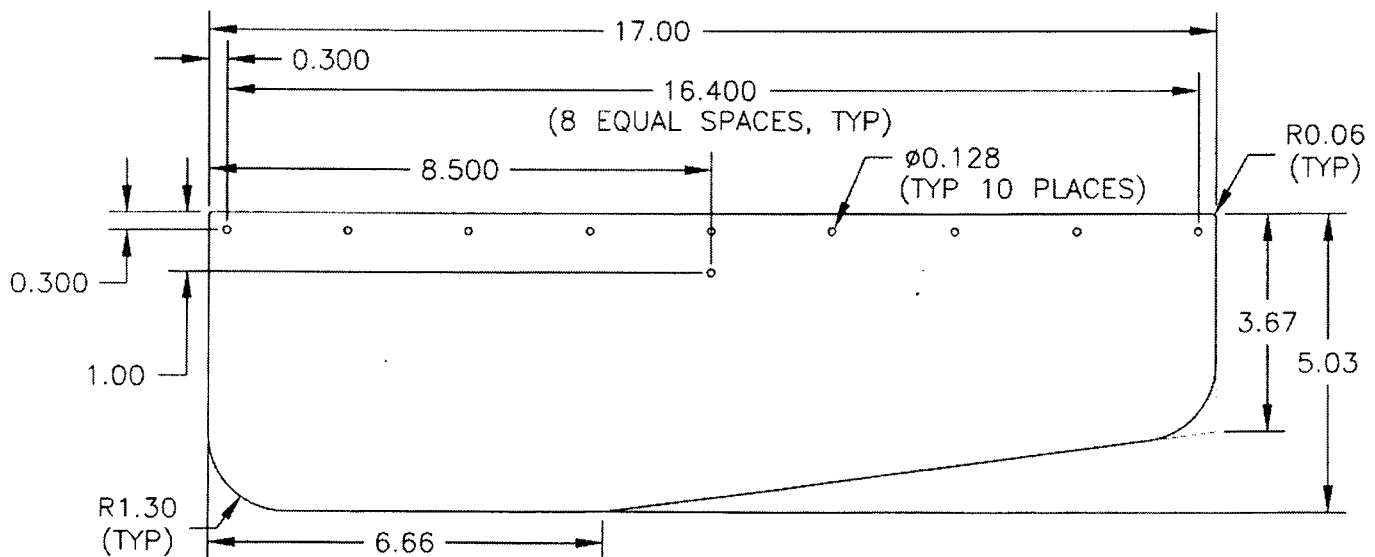
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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WRO 50465

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